

Work Order ID 72108

Tuesday, July 19, 2011 11:16:25 AM



Page 1

Item ID: D4073-3

Accept



Setup Start



Revision ID:

Stop



Item Name: Door Hinge Backing Plate

Start Date: 7/19/2011 Start Qty: 12.00



Cust Item ID:

Required Date: 7/25/2011 Req'd Qty: 12.00



Customer:

Reference:

Approvals:

Process Plan:

Date: 11-07-19 Tooling:

Date:

Run Start



QC:

Date: SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4073	B								

100

0.00



Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg

6061-063

Dwg Rev: B

Prog Rev: B

2-Deburr if necessary

B11-8-3

(15)

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

B11-8-3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Accept



Setup Start



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Stop



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Start Date: 7/19/2011 Start Qty: 12.00



Cust Item ID:

Required Date: 7/25/2011 Req'd Qty: 12.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC8- Inspect parts - second check

0.00

Subs



QC

Memo

0.00

Quality Control

15

130

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

15 of 11/08/03

140

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Memo

0.00

Powder Coating

POWDER COAT:
Start Time: 9:00am
Oven Temperature: 220°
Finish Time: 4:30pm

15 of 11/08/02

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

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Item ID:	D4073-3	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Door Hinge Backing Plate					
Start Date:	7/19/2011	Start Qty:	12.00			
Required Date:	7/25/2011	Req'd Qty:	12.00			
Reference:						
				Cust Item ID:		
				Customer:		

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150 	QC3- Inspect Part Finish	0.00							
QC Quality Control	Memo	0.00							15X 11/08/08
160 	Identify as per dwg & Stock Location: <u>120</u>	0.00							
Packaging Packaging	Memo	0.00							11/8/08 150
170 	QC21- Final Inspection - Work Order Release	0.00							
QC Quality Control	Memo	0.00							CK 11/08/09

11-08-8
15

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

Tuesday, July 19, 2011 11:16:31 AM

Page 1

Work Order ID: 72108

Parent Item: D4073-3

Parent Item Name: Door Hinge Backing Plate





Start Date: 7/19/2011

Required Date: 7/25/2011

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP Rev:A 10.06.08 new issue DD verf:EC
DRAWING REV. CHANGE AS PER ECN 11-598
VERIFIED BY: IPP REV:B
11-07-05 JFS

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.063  6061-T6 .063 Sheet		Purchased	No			100	sf	211.4456	0.02777	0.350779	.5		
											1811-8-3		

Location

MAT021

116308

117285

Loc Qty

211.4455684

26.9755684

184.47

Loc Code

117285

15

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FIRST ARTICLE INSPECTION CHECKLIST

Rev	Date	Change	Revised by	Approved
A	10.10.25	New Issue	KJ	

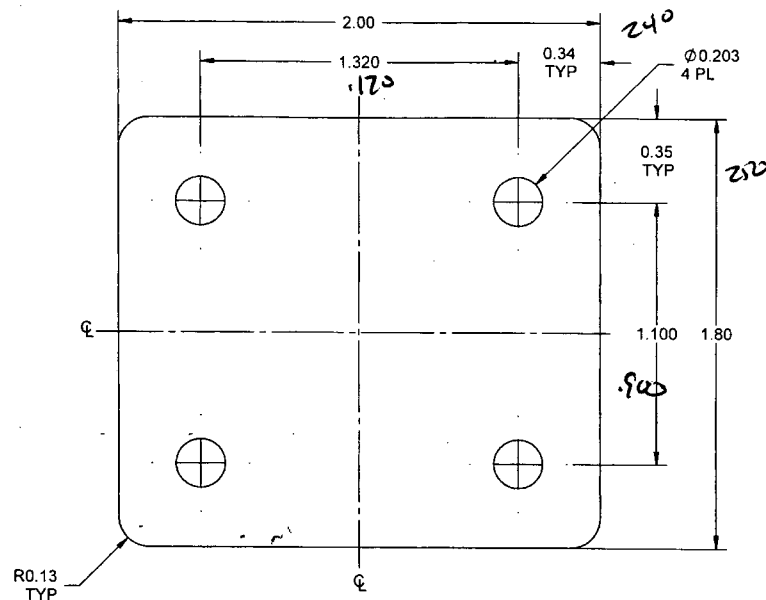
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D4073-3 DOOR HINGE BACKING PLATE

NOTES:

- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET, 0.063 THICK
PER QQ-A-250/11 OR AMS-QQ-A-250/11
OR AMS 4025 OR AMS 4027
OR ASTM B209
REF DART SPEC M6061T6S.063
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: PER QSI 044 6.1
- 7) WEIGHT: 0.02 lbs

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 12408

RELEASED
2011-06-30
NR

DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	RF	PORT HADLOCK, WA	
CHECKED	RF	DRAWING NO.	REV. B
MFG. APPR.	RF	D4073	SHEET 2 OF 2
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	DOOR HINGE	NTS
DATE	11.05.02	COPYRIGHT © 2010 BY DART AEROSPACE USA, INC.	
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